

# Work Order ID 79940

**\*79940\***

Page 1

February-07-12 3:07:59 PM

Item ID: D117-762-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 07/02/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 21/02/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: M.L.S Date: 12/02/07 Tooling:

Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3492	C
D3582	Rev A

100 **\*100\*** DOCUMENT CONTROL 0.00

DC Memo 0.00

Document Control Photocopy bluefile & type labels per PPP D117-762-041 CHG001

120 **\*120\*** BENDING MACHINE - SKIDTUBES 0.00

CNC Bend 1 Memo 0.00

CNC Delta 100 Bender Bend tube as per program D3582 on CNC Bender and Dwg D3582. Folio 3, use bending aid DT9632 2- cut fwd end of tube as per dwg

*N/A*

*DC 12/02/22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00

**\*130\***

Skidtubes

Skidtubes

Memo

1-Cut Aft end using DT8185

2-Deburr ends

3-Drill Aft Cap holes using DT8678 \*\*\* OPEN AFT CAP HOLE TO .187" \*\*\*

4-Locate DT 8973 from aft cap holes &amp; Drill Ground wire hole on top of Tube.

5-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill.

6-Drill pilot holes for wearplates using DT8900

7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.

8- open ground wear holes to 0.391" as per section B-B

9-Open Aft Cap holes using .209" drill.

10-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size.

0.00

CF 12-3-13

CF 12-02-22

CF 12-3-13

SAD

12-03-15

W/O:		WORK ORDER CHANGES					
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**\*79940\***

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**\*N900040100\***

Setup Start **\*NS1\***

Stop \*NS2\*

**Start Date:** 07/02/2012    **Start Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Required Date:** 21/02/2012      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00

**\*140\***

## Skidtubes

## Skidtubes

## Memo

0.00

## Skidtubes

1-Weld fwd cap D2964 per dwg D3582 and QSI 004

A/R AL ROD

Batch *M 120164*

2-Grind flush

CF

150

QC10- Inspect visual per QSI004- ground welds

0.00

**\*150\***

QC

## Memo

0.00

## Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

\*160\*

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item Name: Replacement Skidtube

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Required Date: 21/02/2012 Req'd Qty: 1.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Chemical Conversion Coat per QSI005 4.1

0.00

**\*170\***

HandFinish

Memo

0.00

Hand Finishing

1 Ø CF 12-3-15

180

QC3- Inspect Part Finish

0.00

**\*180\***

QC

Memo

0.00

Quality Control

① SAD 12-03-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

0.00

**\*100\***

Skidtubes

Skidtubes

Memo

0.00

1-Open X-Bolt holes to finish size as per Dwg D3582, all sections

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube, prep. tube for welding.

4-Bond web as per Dwg D3582 & QSI 015

A/R 241 Sike Flex Batch: M120813  
Exp Date: 2012-08-13

5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B.

A/R AL ROD Batch: m120164

6-Grind welds flush

→ CF BE 12-03-17  
12-3-19

200

QC10- Inspect visual per QSI004- ground welds

0.00

**\*200\***

QC

Memo

0.00

Quality Control

12-03-19 1 φ

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC5- Inspect part completeness to step on W/O	0.00							
<b>*210*</b>									
QC	Memo	0.00							
Quality Control									
215	Pressure Wash per QSI005 4.3	0.00							
<b>*215*</b>									
HandFinish	Memo	0.00							
Hand Finishing	Touch-up alodine as per QSI								
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*220*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME 10h45 OVEN TEMPERATURE: 320°F FINISH TIME: 11h15								

m 120 222

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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\*1\*

Cust Item ID:

Required Date: 21/02/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

230

QC3- Inspect Part Finish

0.00

\*230\*

QC

Memo

0.00

Quality Control

IXP/M-12/03/22

250

HandFinishing

0.00

\*250\*

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign objects

2-Install Aft cap as per Dwg D3582, Detail "C"

A/R 241 Sika Flex Batch:

Exp Date:

3-Install Wearplates as per Dwg D3582,

Note:Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582

\*\*\*\*\*Do not install bolts where indicated on Dwg(Note #6)\*\*\*\*\*

A/R 241 Sika Flex Batch:

Exp Date:

4-assemble o'ring as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch:

5- Wing Walk as per Dwg D3582 and QSI 005 4.4

119094

IXP/M-12/03/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*79940\***

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**\*1\***

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

260

QC5- Inspect part completeness to step on W/O

0.00

**\*260\***

QC

Memo

0.00

Quality Control

270

Packaging

0.00

**\*270\***

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D117-762-041

Location:                     

PPP Rev:                     

280

QC21- Final Inspection - Work Order Release

0.00

**\*280\***

QC

Memo

0.00

Quality Control

*Scrubber*

*AP 79915*

*12/3/29*

*12/3/29*

*12/203-29*

W/O:		WORK ORDER CHANGES					
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**\*79940\***

**\*D117-762-041\***

**Required Date:** 21/02/2012

**Required Qty: 1.00**

IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-11 <b>*D3492-11*</b> Plug		Manufactured	No			250	Each	26.0000	2	2			
				<u>Location</u>									
				FP002				26					
				71863				6					
				74732				20					
D3492-13 <b>*D3492-13*</b> Plug		Manufactured	No			250	Each	26.0000	6	6			
				<u>Location</u>									
				FP001				26					
				74034				26					
D3492-9 <b>*D3492-9*</b> Plug		Manufactured	No			250	Each	13.0000	2	2			
				<u>Location</u>									
				FP002				13					
				46694				13					
D2962-150 <b>*D2962-150*</b> 3.540 Outer Tube, Extrut		Manufactured	No				Each	49.0000		1			
				<u>Location</u>									
				HALL				49					
				59934				49					

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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\*79940\*

Parent Item: D117-762-041

\*D117-762-041\*

Parent Item Name: Replacement Skidtube

Start Date: 07/02/2012

Required Date: 21/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2964	Manufactured	No	140	Each	29.0000	1	1
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\*D2964\*

Cap

\*\*

BE 12/03/15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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LG002	29	
74719	29	

D2971	Manufactured	No	190	Each	34.0000	1	1
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\*D2971\*

Cross Bolt Spacer

\*\*

BE 12/03/16

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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LG001	34	
74720	34	

D3584-1	Manufactured	No	190	Each	2.0000	1	1
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\*D3584-1\*

Web

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SAO 12-03-15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG	2	
75189	2	

D2973	Manufactured	No	190	Each	58.0000	2	2
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\*D2973\*

Cross Bolt Spacer

\*\*

BE 12/03/16

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG002	58	
14636	58	

D3662-3	Manufactured	No	190	Each	1.0000	1	1
---------	--------------	----	-----	------	--------	---	---

\*D3662-3\*

Crossbolt Spacer

\*\*

BE 12/03/16

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG001	1	
44456	1	

W/O:		WORK ORDER CHANGES					
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Parent Item: D117-762-041

\*D117-762-041\*

Parent Item Name: Replacement Skidtube

Start Date: 07/02/2012

Required Date: 21/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3662-1 Manufactured No

190 Each 25.0000 3 3

\*D3662-1\*

Crossbolt Spacer

\*\*

BE12/03/16

Location Loc Qty Loc Code

LG001 25  
71799 1  
71857 24

ALS4-1032-130 Purchased No

Each 1,823.000 36

\*AI S4-1032-130\*

Insert

\*\*

120181

36 M-L 12/03/22

Location Loc Qty Loc Code

ST280 744  
119084 744  
ST281 1079  
119632 79  
120410 1000

ALS4-428-165 Purchased No

Each 469.0000 2

\*AI S4-428-165\*

Inserts

\*\*

M-L 12/03/22

Location Loc Qty Loc Code

FP002 469  
114172 18  
117769 451

D2965 Manufactured No

250 Each 22.0000 1 1

\*D2965\*

Cap, 105 Skidtube

\*\*

M-L 12/03/22

Location Loc Qty Loc Code

FP002 22  
71371 22

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Start Date: 07/02/2012

Required Date: 21/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3508-3 Manufactured No

250

Each

11.0000

1

1

**\*D3508-3\***

Wearplate

\*\*

*M-L 12/03/22*

Location

Loc Qty

Loc Code

FP001

11

38527

1

76264 ✓

10

D3508-9 Manufactured No

250

Each

6.0000

1

1

**\*D3508-9\***

Wearplate

\*\*

*M-L 12/03/22*

Location

Loc Qty

Loc Code

FP001

6

72203 ✓

6

D3558-3 Manufactured No

250

Each

11.0000

1

1

**\*D3558-3\***

Gasket

\*\*

*M-L 12/03/22*

Location

Loc Qty

Loc Code

FP002

11

71651

1

75179 ✓

10

D3558-9 Manufactured No

250

Each

4.0000

1

1

**\*D3558-9\***

Gasket

\*\*

*M-L 12/03/22*

Location

Loc Qty

Loc Code

FP002

4

71212 ✓

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 5

Work Order ID: 79940

\*79940\*

Parent Item: D117-762-041

\*D117-762-041\*

Parent Item Name: Replacement Skidtube

Start Date: 07/02/2012

Required Date: 21/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3558-11

Manufactured No

250

Each

5.0000

1

1

\*D3558-11\*

Gasket

\*\*

m-l 12/03/22

Location

Loc Qty

Loc Code

FP002

5

72202 ✓

5

D3558-13

Manufactured No

250

Each

9.0000

1

1

\*D3558-13\*

Gasket

\*\*

m-l 12/03/22

Location

Loc Qty

Loc Code

FP002

9

59558 ✓

9

D3508-11

Manufactured No

250

Each

4.0000

1

1

\*D3508-11\*

Wearplate

\*\*

m-l 12/03/22

Location

Loc Qty

Loc Code

FP001

4

72011 ✓

4

D3508-13

Manufactured No

250

Each

11.0000

1

1

\*D3508-13\*

Wearplate

\*\*

m-l 12/03/22

Location

Loc Qty

Loc Code

FP001

11

71027 ✓

2

71794

9

AN960JD10L

NAS1149D0332J Purchased

No

250

Each

0.0000

2

2

\*AN960JD10L \*

Washer

\*\*

120644

m-l 12/03/22

2

#

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 6

Work Order ID: 79940

\*79940\*

Parent Item: D117-762-041

\*D117-762-041\*

Parent Item Name: Replacement Skidtube

Start Date: 07/02/2012

Required Date: 21/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

250

Each

3,845.000

28

\*AN3C4A\*

BOLT

120769

\*\*

28  
m. 12/03/22  
28

## Location

## Loc Qty

## Loc Code

ST350

3845

117313

2

117688

5

117872

10

118112

16

118451

2

119749

310

120187

2000

120423

500

120521

1000

AN3C5A

Purchased

No

250

Each

1,336.000

2

\*AN3C5A\*

Bolt

\*\*

m. 12/03/22

## Location

## Loc Qty

## Loc Code

FP001

7

115835

7

ST350

1329

116419

28

117343

13

117764

7

117872

2

119127

252

119749

27

120423 ✓

1000

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 7

Work Order ID: 79940

\*79940\*

Parent Item: D117-762-041

\*D117-762-041\*

Parent Item Name: Replacement Skidtube

Start Date: 07/02/2012

Required Date: 21/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN960JD416L NAS1149D0416J Purchased No

\*AN960JD416I \*

Washer

250 Each 8.0000 2 2

\*\*

Location

Loc Qty

Loc Code

FP002

8

110153

8

AN960C10L NAS1149C0332 R Purchased No

\*AN960C10I \*

washer

250 Each 0.0000 28 28

\*\*

AN4-4A

Purchased No

\*AN4-4A\*

Bolt

250 Each 127.0000 2 2

\*\*

Location

Loc Qty

Loc Code

FP001

10

114615 ✓

10

ST355

117

114615

17

120187

100

NAS1611-012 Purchased No

\*NAS1611-012\*

O-RING

250 Each 54.0000 6 6

\*\*

Location

Loc Qty

Loc Code

FP001

54

113845 ✓

10

118384 ✓

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February-07-12 3:08:03 PM

Page 8

Work Order ID: 79940

**\*79940\***

Parent Item: D117-762-041

**\*D117-762-041\***

Parent Item Name: Replacement Skidtube

Start Date: 07/02/2012

Required Date: 21/02/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-015

Purchased

No

250

Each

119.0000

2

2

**\*NAS1611-015\***

O-RING

\*\*

*M-12/03/22*

Location

Loc Qty

Loc Code

FP001

119

115101

85

116081 ✓

34

*2*

NAS1611-016

Purchased

No

250

Each

72.0000

2

2

**\*NAS1611-016\***

O-RING

\*\*

*M-12/03/22*

Location

Loc Qty

Loc Code

FP001

72

112492

46

113524 ✓

26

*2*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

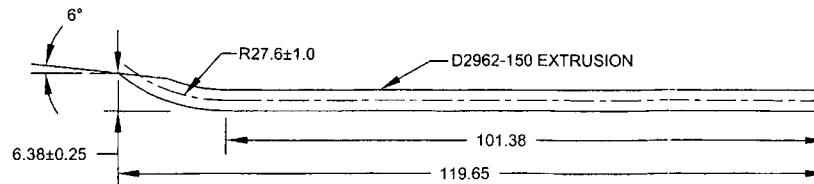


# PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

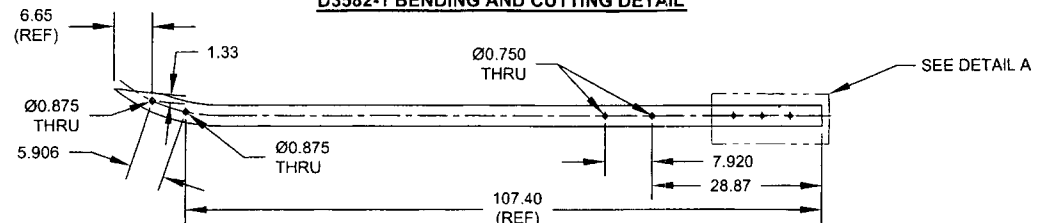
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

## GENERAL NOTES:

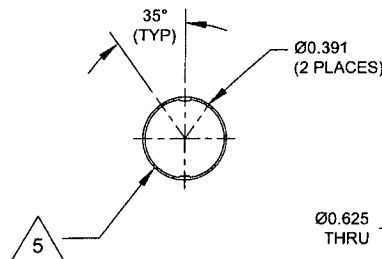
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004.
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- FINISH:
  - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
  - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
  - ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4.



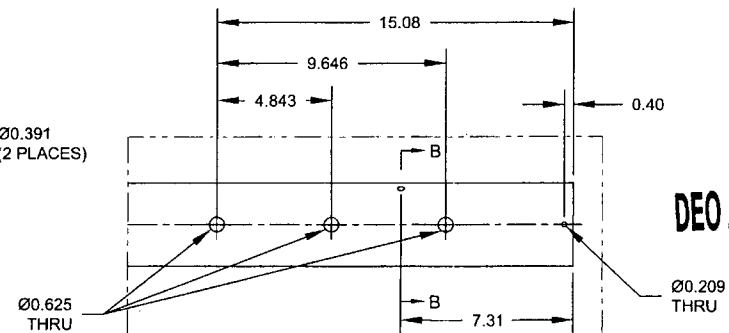
D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B  
SCALE 1:5



DETAIL A  
SCALE 1:5

DEO ATTACHED

RELEASED  
07.11.22

REV.	DESCRIPTION	PH	DATE
A	NEW ISSUE	PH	07.06.08
DESIGN	BY	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	BY		
CHECKED	BY		
MFG. APPR.	BY		
DE APPR.	BY		
DATE	07.06.08	DRAWING NO.	REV. A
		D3582	SHEET 1 OF 2
		TITLE	SCALE
		BK 117 SKIDTUBE ASSEMBLY	1:20
COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

79940 MCO  
12/02/07

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

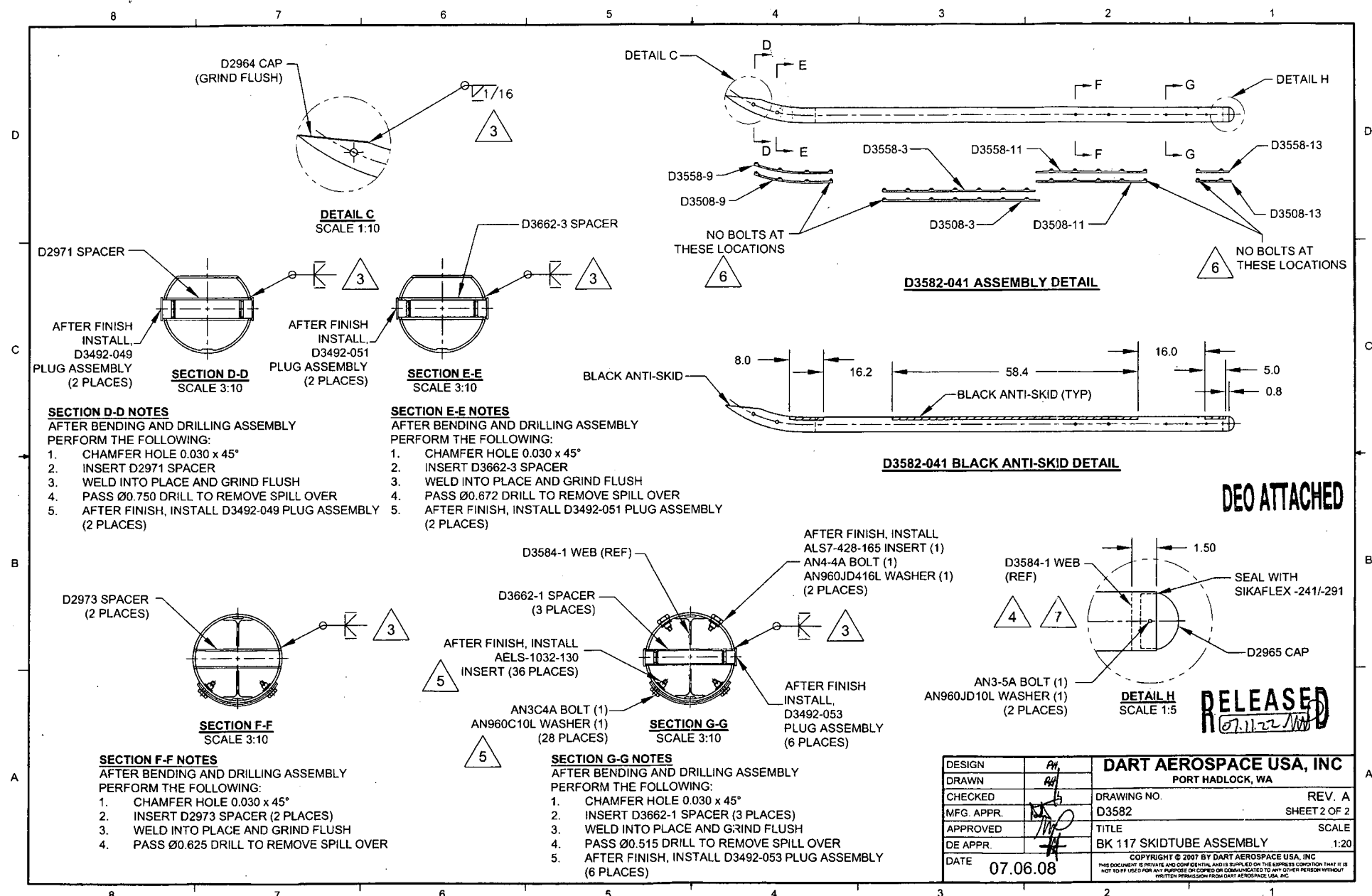
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

79946



DEO ATTACHED

RELEASED

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3582	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	BK 117 SKIDTUBE ASSEMBLY	1:20
DATE	07.06.08	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

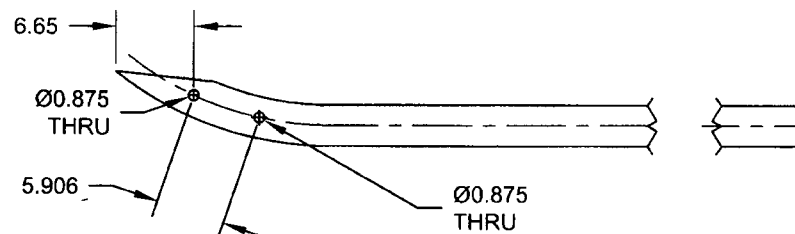
**NOTE:** Date & initial all entries

799-00

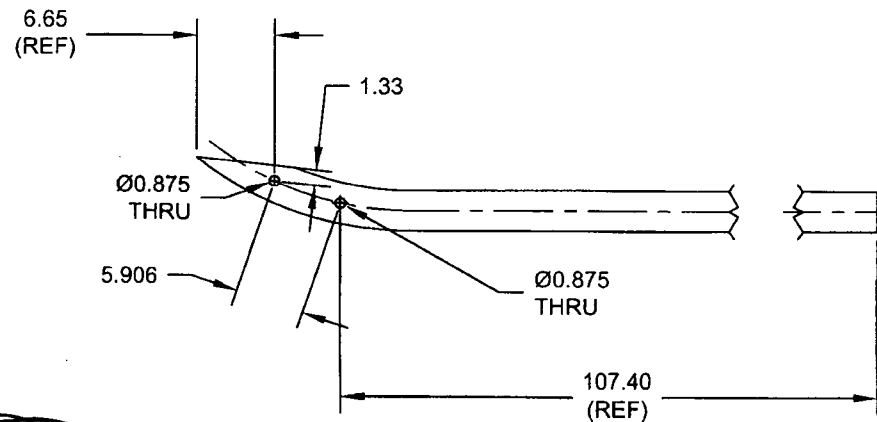
DRAWING NO. D3582	TITLE BK 117 SKIDTUBE ASSEMBLY	REV. A	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3582-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>PH</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.04.06	DATE 04.04.06	DATE 09.04.06	DATE 12/04/06		DATE 09.04.06		

FOR EASE OF MANUFACTURE AND TO ENSURE THE FIT OF BRISTOL WIRESTRIKE SKID GEAR DEFLECTOR:  
UPDATE DIMENSIONING OF 2 FWD HOLES ON SHEET 1 AS SHOWN

IS:



WAS:



**RELEASED**  
09/04/22 *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries